

Date: Tuesday, 21/10/2008 2:46:01 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 42777	Part Number	: D2743
Estimate Number	: 10329	Drawing Number	: D2743 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 21/10/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : MACHINED PARTS	Due Date	: 15/11/2008
Previous Run	: 41128	Qty:	114 Um: Each
Written By	:		
Checked & Approved By	: <u>JUD 08.10.21</u>		
Comment	: Est E 05.04.13 Reformat; removed tumble and deburr step KJ/J LM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6T0625W065	6061-T6 RD Tube .625 x.065W
-----	------------------	-----------------------------



No more mat



114

Comment: Qty.: 0.2800 f(s)/Unit Total : 56.0070 f(s)

Material: 6061-T6 (WW-T-700/6)

Ø0.625 " x 0.065" wall

(M6061T6T0.625W.065)

Batch: m108091

mt 08/10/25

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



114

Comment: 1-TURN AS PER FOLIO FA202 & DWG D2743

FOLIO REV: ADWG REV: B

2-DEBURR AS REQUIRED

mt 08/10/25

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



114

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mt 08/10/25

4.0	QC8	SECOND CHECK
-----	-----	--------------



114

Comment: SECOND CHECK

SA 08/10/28

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



114

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BARTHE

8/10/28

114

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/10/2008 2:46:01 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 42777

Part Number: D2743

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



114

Comment: FINAL INSPECTION/W/O RELEASE

08/10/09

Job Completion



08/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

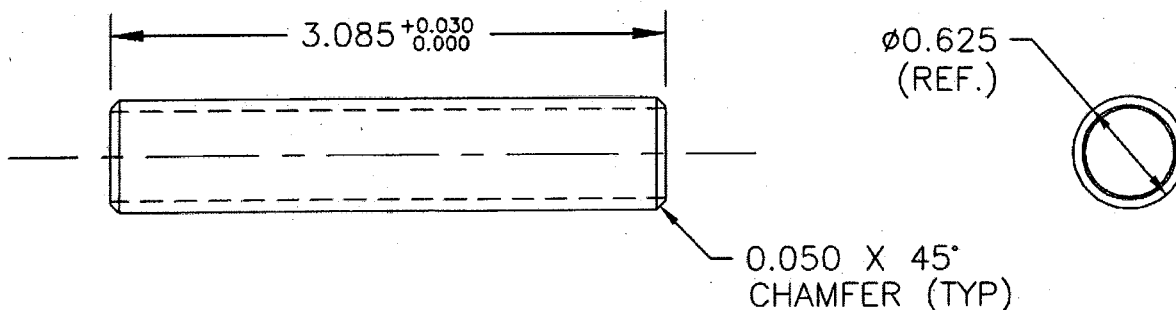
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>HA</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>HA</i>	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED
98.12.16 DS



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42772